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D2561

Job Sheet 184801



Part No: D2561

Job Qty: 20 ea

Part Name: Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP C 00.05.19 Added inspect level 8 EC IPP Rev:D Now on Waterjet 06-06-14 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	20 pcs		11/16/18	0.01	1.06	Waterjet 1		pc 18/10/25
120	QC	20 pcs		11/16/18	0.00	0.00	QC2		pc 18/10/25
140	QC	20 pcs		11/16/18	0.00	0.00	QC8		38
150	Packaging	20 pcs		11/16/18	0.00	0.00	Packaging3		10/12 9-89
160	QC21-SA	20 Ea		11/16/18	0.00	0.00	QC21		DAS 21 9-89
Part Op 100 - 1-Cut as per Dwg D2561 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary									
Descriptions: 150 - *** STOCK IN STEP CELL *** LOCATION WA003									

NOV 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	2.8000 sf (.14 ea)	100-Waterjet	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6S.250	3	21	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug Plate	0.500inches $\pm$ 0.010	0.510 0.490		
2	Lug Plate	2.525inches $\pm$ 0.010	2.535 2.515		
3	Lug Plate	3.975inches $\pm$ 0.010	3.985 3.965		
4	Lug Plate	0.257inches + 0.005 - 0.000	0.262 0.257		
5	Lug Plate	4.525inches $\pm$ 0.010	4.535 4.515		
6	Lug Plate	5.025inches $\pm$ 0.010	5.035 5.015		
7	Lug Plate	0.250inches $\pm$ 0.030	0.280 0.220		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Container No: S122010



Part: D2561

Job No: 184801

Serial No/Batch: S122010

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/26/18

